



Dart Aerospace Ltd.
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Tel (613) 632-5200
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RBW6505G00431-3T

Job Sheet 198891



Part No: RBW6505G00431-3T

Job Qty: 1 pcs

Part Name: AW139 Trd Support Bearing Repair Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 10/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 16173

Note: DWG RBW6505G00431-3T Rev.3 IPP Rev. A 19.02.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Small Fab - 1	1 pcs	10/9/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
100	Small Fab - 2 - B4B	1 pcs	10/9/19		0.00	1.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
							Small Fab - 8 - B4B		
110	QC 5	1 pcs	10/9/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		

GP 19-10-17

GP 19-10-17

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				QC 5 - 30		DAS
				QC 5 - 40		OCT 17 2019 40
				QC 5 - 61		9-89
				QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	10/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	M/L
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
140	QC 21 - FG	1 pcs	10/9/19	0.00 0.00	QC 21 - FG - 21	21
					QC 21 - FG - 70	9-89
					QC 21 - FG - 53	OCT 18 2019

Part Op 90 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-
 Descriptions: 1510-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBW6505G00431-3T-13 to RBW6505G00431-3T-9 foam as per DWG. 6-Glue foam to case and pack case as per DWG.
 100 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 APP-1510-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBW6505G00431-3T-13 to RBW6505G00431-3T-9 foam as per DWG. 6-Glue foam to case and pack case as per DWG.
 110 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1510-E	Case G2F	1 Ea (1 ea)	90-Small Fab - 1	159797
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	100-Small Fab - 2 - B4B	021040
RBW6500X01611W142B-3T	Shaft Support Bearing Removal 106	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5166737
RBW6505G00431-3T-11	Bottom Foam use in case APP-1510-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	154798
RBW6505G00431-3T-13	Contents Placard 98	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5208372
RBW6505G00431-3T-9	Lid Foam use in case APP-1510-E	1 Ea (1 ea)	100-Small Fab - 2 - B4B	159800
RBW6510A00436W142B-3T	Bearing Assembly Press/Support Tool TBD	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5211713
RBW6510A00436W142C-3T	Shaft Support Tool Bearing Support Housing 152	1 pcs (1 ea)	100-Small Fab - 2 - B4B	5210059
RBW6510A00436W142D-3T	Wrench, Shurlock, Bearing Support Housing	1 pcs (1 ea)	100-Small Fab - 2 - B4B	183698
97524A032	Sealing Blind Rivet 152B	4 Ea (4 ea)	100-Small Fab - 2 - B4B	5206761

012458

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - 1	APP-1510-E	1	1	0
100-Small Fab - 2 - B4B	97524A032	4	149	0
	RB41011	1	262	0
	RBW6500X01611W142B-3T	1	1	0
	RBW6505G00431-3T-11	1	1	0
	RBW6505G00431-3T-13	1	0	0
	RBW6505G00431-3T-9	1	1	0
	RBW6510A00436W142B-3T	1	0	0
	RBW6510A00436W142C-3T	1	0	0
	RBW6510A00436W142D-3T	1	4	0

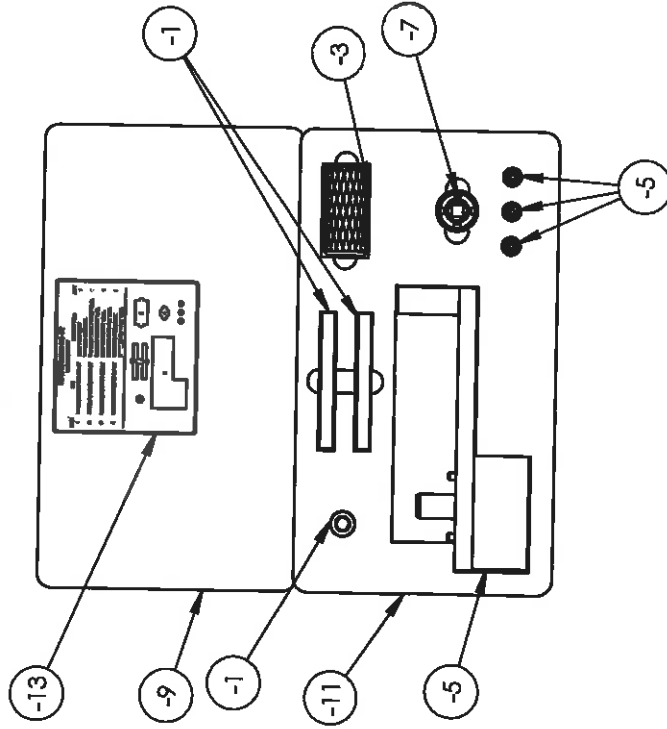
Part Specifications

Specifications could not be found.

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REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	SHT 3 MODIFIED CUTOOTS. SHT 4 CORRECTED QTY'S TO 1. ADDED ITEM NUMBERS ON LAYOUT VIEW	2/6/2012	JAG	
2	-13 CHD MATERIAL WAS ALUMINUM IS PLASTIC. -9 ADDED CUTOFF FOR CLEARANCE TO BOTTOM OF FOAM.	3/12/2013	BIM	RJC
3	-13 CORRECTED P/NS. WAS RBW6500X01611W142B-3T IS RBW6500X01611W142B-3T.	5/19/2014	JAG	RJC



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WITHOUT NOTICE
WORK ORDER
NO 198891 HUS
19-08-07

REF P/N 3T6505G00431

ASSY		B/O		Part #		UNIT		Description		Material		B/O INFORMATION OR SPECIFICATIONS		PG.	
				-1		1		SHAFT SUPPORT BEARING REMOVAL				RBW6500X01611W142B-3T		1	
				-3		1		BEARING ASSEMBLY PRESS TOOL, BEARING SUPPORT HOUSING				RBW6510A00436W142B-3T		1	
				-5		1		SHAFT SUPPORT TOOL, BEARING SUPPORT HOUSING				RBW6510A00436W142C-3T		1	
				-7		1		WRENCH, SHURLOCK, BEARING SUPPORT HOUSING				RBW6510A00436W142C-3T		1	
				-9		1		LID FOAM		C200, BLACK, FLAT		1-3/4 X 11-1/4 X 20-1/8		2	
				-11		1		BOTTOM FOAM		Y20, BLACK		5-5/8 X 11-1/4 X 20-1/8		3	
				-13		1		CONTENTS PLACARD		PLASTIC		1/16 X 6 X 6-1/2		4	
				-15		1		RED BARN PLACARD		ALUMINUM		RB41009		NS	
				-17		1		PELICAN CASE		PLASTIC		BLACK, PELICAN #APP-1510-E		NS	

RED BARN MACHINE

TRD SUPPORT TOOL KIT

DWG NO. RBW6505G00431-3T

REV 3

DRAWN BY: GILBERT

APPROVED

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS $\pm 1/32$
DECIMALS $\pm .01$
ANGLES $\pm .8^\circ$

1. BREAK ALL SHARP EDGES .015 X 45°
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

USED ON MODEL AW139

DATE 10/14/2011

SHEET 1 OF 4

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Engineering																																	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Water Jet ☐ Supplier ☐ Quality ☐																															
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)																																	
Description Work Order Deviation				Disposition																																			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>								Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Other/Details: _____																																							
Completed By				Lead hand / Supervisor				QC / QA Coordinator																															